

Work Order ID 58549

Monday, May 10, 2010 3:09:54 PM



For Friday

Page 1

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 5/10/2010 Start Qty: 50.00



Cust Item ID:

Required Date: 5/13/2010 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: UMFDate: 10-5-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3910

B

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

Cut to 1.450" Long

0.00 ank 10/05/10500

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV: AADWG REV: 3

DEBURR

0.00

SL / ank 10/05/13500

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept

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Item Name: Crosstube Lug

Start Date: 5/10/2010 Start Qty: 50.00

Required Date: 5/13/2010 Req'd Qty: 50.00

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SL/aml 10/05/13

50

0

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B.A 10/05/13

50

0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

50 BR 10-5-13.

W/O:			WORK ORDER CHANGES					
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Page 3

Item ID:	D3910-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Crosstube Lug				Stop	
Start Date:	5/10/2010	Start Qty: 50.00		Cust Item ID:		
Required Date:	5/13/2010	Req'd Qty: 50.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo: START: 2:30pm Temp: 320°F Fin: 3:00pm	0.00 0.00	=> 10/05/13			50	0		
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				50			BR 10-5-13
170 Packaging Packaging	Identify as per dwg & Stock Location: 507 Memo	0.00 0.00							6/10/14 (50)

W/O:			WORK ORDER CHANGES					
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Resolution _____ Disposition: _____ QA: N/C Closed: _____ Date: _____





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NOTE: Date & initial all entries


Work Order ID 58549

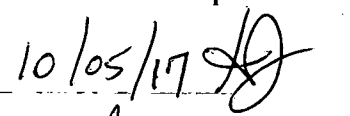
Monday, May 10, 2010 3:09:54 PM

Page 4

Item ID: D3910-3 Accept  Setup Start 
Revision ID: Stop 
Item Name: Crosstube Lug
Start Date: 5/10/2010 Start Qty: 50.00  Cust Item ID:
Required Date: 5/13/2010 Req'd Qty: 50.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

10/05/17 
10-5-14
50

W/O:			WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, May 10, 2010 3:09:53 PM

Page 1

Work Order ID: 58549



Parent Item: D3910-3



Parent Item Name: Crosstube Lug

Start Date: 5/10/2010

Required Date: 5/13/2010

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	484.5637	0.13			
Lug Extrusion												

Location

Loc Qty

Loc Code

MAT06

484.5636895

43722

180

→ 45800

304.563689

6.84211 and 10/10/10

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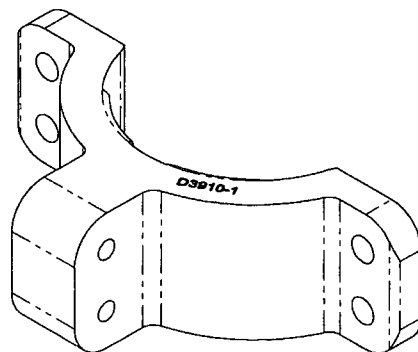
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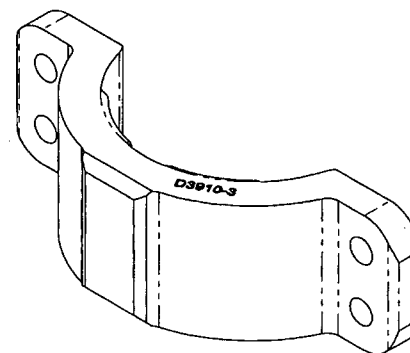
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D3910-1 X-TUBE LUG





D3910-3 X-TUBE LUG

#58549

RELEASED
2010-03-22
MD

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 \pm 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-807-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED		DRAWING NO. D3910	REV. B	
MFG. APPR.			SHEET 1 OF 3	
APPROVED		TITLE	SCALE NTS	
DE APPR.		X-TUBE LUG (350)		
DATE	10.03.16		COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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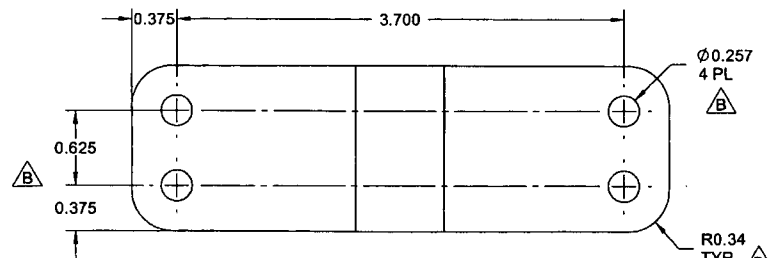
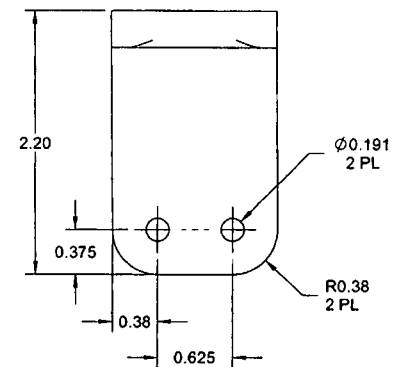
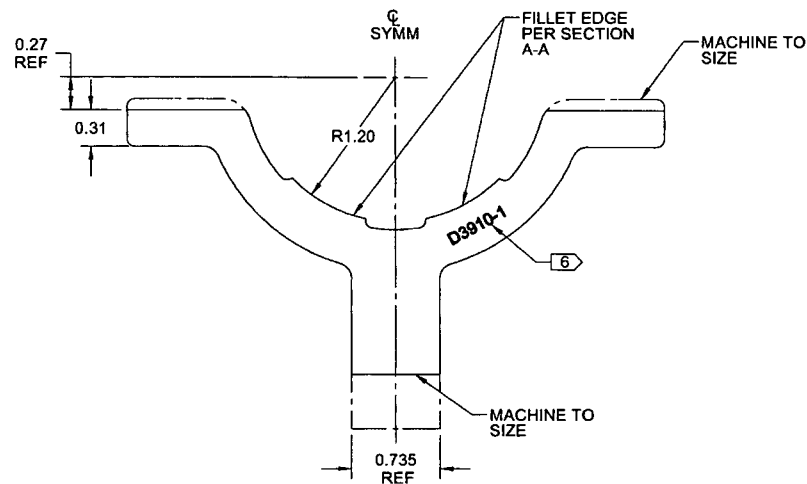
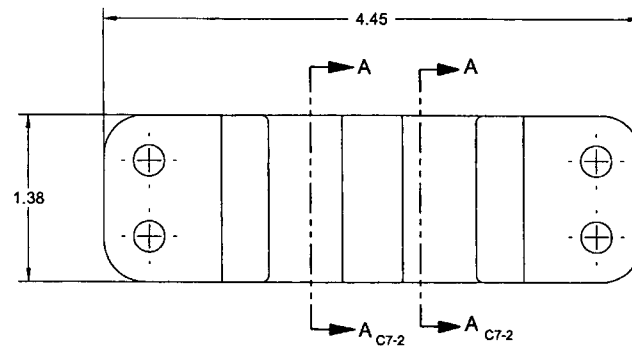
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ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A
C4-2
C5-2



D3910-1 X-TUBE LUG

RELEASED
2010-03-22

DESIGN	A/S	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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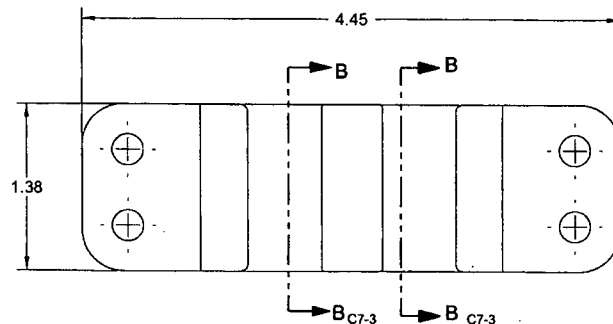
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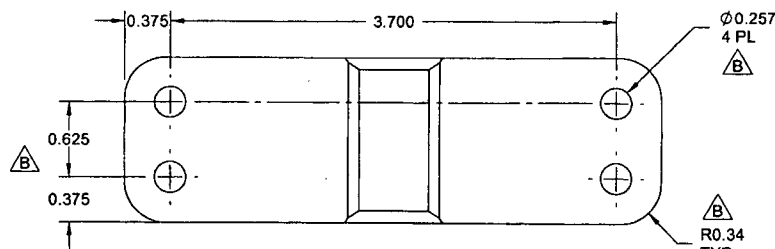
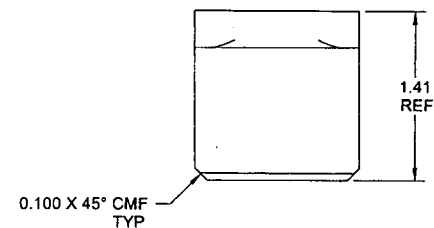
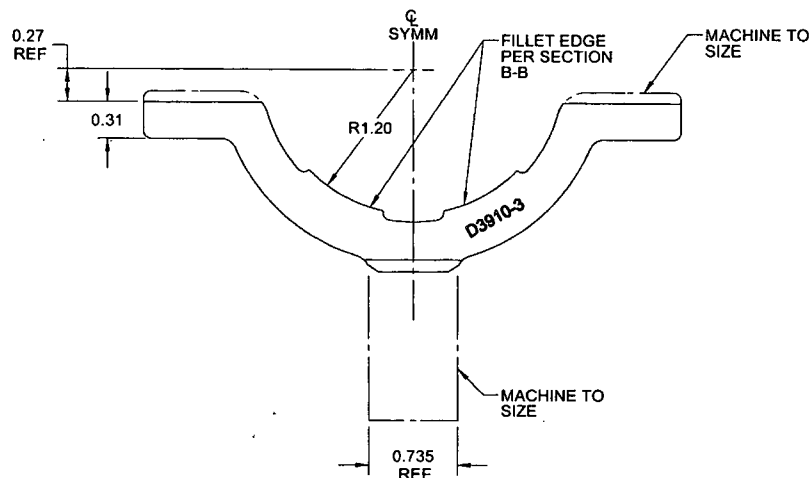


ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B
C4-3
C5-3



#58549



RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
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